

SETUP & OPERATION MANUAL

FEATURES

- ⚙ Powerful 2 HP 15 A motor with thermal overload protection.
- ⚙ Front and rear fold-down extension tables for smooth easy stock feeding.
- ⚙ Top mounted rollers for multiple passes.
- ⚙ Built-in inset lifting handles.
- ⚙ Large depth of cut adjustment handle – one full rotation equals 1/16".
- ⚙ Easy to read thickness indicator with graduated scale in inches and metric.
- ⚙ Safety on/off switch with key. Unit cannot be started when key is removed from switch.
- ⚙ Depth of cut indicator.
- ⚙ Helical cutter head with 26 reversible two-sided high speed steel inserts.

SPECIFICATIONS

TABLE AREA WITH EXTENSIONS (L X W)
28 3/8" X 13" (720 X 330 MM)

MAXIMUM PLANING WIDTH
13" (330 MM)

MAXIMUM THICKNESS OF STOCK
6" (152 mm)

MINIMUM THICKNESS OF STOCK
1/8" (3 mm)

MINIMUM LENGTH OF STOCK
5" (127 MM)

MAXIMUM DEPTH OF CUT (FULL WIDTH)
1/16" (1.5 MM)

CUTTER HEAD SPEED
9700 RPM

FEED SPEED
26 FPM

MOTOR
2 HP, 120 V, 1 PH, 15 A

WEIGHT
59 LBS (27 KG)

13" PLANER WITH HELICAL CUTTER HEAD



MODEL #30-005HC MI





GENERAL® INTERNATIONAL

8360 Champ-d'Eau, Montreal (Quebec) Canada H1P 1Y3
Telephone (514) 326-1161 • Fax (514) 326-5555 • www.general.ca

THANK YOU for choosing this General® International model 30-005HC M1 13" Planer with Helical Cutter Head. This planer has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. For your safety, as well as to ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this planer as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

Disclaimer: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corres-

ponds with that of the unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of planer and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your machine exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

GENERAL® & GENERAL® INTERNATIONAL WARRANTY

All component parts of General®, General® International and Excalibur by General International® products are carefully inspected during all stages of production and each unit is thoroughly inspected upon completion of assembly.

Limited Lifetime Warranty

Because of our commitment to quality and customer satisfaction, General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser for the life of the tool. *However, the Limited Lifetime Warranty does not cover any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our Standard 2-year Limited Warranty only. The Limited Lifetime Warranty is also subject to the "Conditions and Exceptions" as listed below.*

Standard 2-Year Limited Warranty

All products not covered by our lifetime warranty including products used in commercial, industrial and educational applications are warranted for a period of 2 years (24 months) from the date of purchase. General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser during this 2-year warranty period, subject to the "conditions and exceptions" as listed below.

To file a Claim

To file a claim under our Standard 2-year Limited Warranty or under our Limited Lifetime Warranty, all defective parts, components or machinery must be returned freight or postage prepaid to General® International, or to a nearby distributor, repair center or other location designated by General® International. For further details call our service department at 1-888-949-1161 or your local distributor for assistance when filing your claim.

Along with the return of the product being claimed for warranty, a copy of the original proof of purchase and a "letter of claim" must be included (a warranty claim form can also be used and can be obtained, upon request, from General® International or an authorized distributor) clearly stating the model and serial number of the unit (if applicable) and including an explanation of the complaint or presumed defect in material or workmanship.

CONDITIONS AND EXCEPTIONS:

This coverage is extended to the original purchaser only. Prior warranty registration is not required but documented proof of purchase i.e. a copy of original sales invoice or receipt showing the date and location of the purchase as well as the purchase price paid, must be provided at the time of claim.

Warranty does not include failures, breakage or defects deemed after inspection by General® or General® International to have been directly or indirectly caused by or resulting from; improper use, or lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any generally considered consumable parts or components.

Repairs made without the written consent of General® International will void all warranty.

TABLE OF CONTENTS

Rules for safe operation	5
---------------------------------	----------

Electrical requirements	6
--------------------------------	----------

Grounding instructions	6
------------------------	---

Circuit capacity	6
------------------	---

Extension cords	6
-----------------	---

Identification of main parts and components	7
--	----------

Unpacking	8
------------------	----------

Assembly Instruction	9
-----------------------------	----------

Attach the depth of cut adjustment handle	9
---	---

Attach the dust chute	9
-----------------------	---

Basic Adjustments and Controls	10
---------------------------------------	-----------

Connecting to a power source	10
------------------------------	----

On/Off power switch	10
---------------------	----

Surge protection/Circuit breaker	10
----------------------------------	----

Raising/Lowering the cutter head	11
----------------------------------	----

Pre-set tickness stop gauge	11
-----------------------------	----

Depth of cut indicator	11
------------------------	----

Operating Instructions	12
-------------------------------	-----------

Basic principles of planing	12
-----------------------------	----

Selecting boards suitable for planing	12
---------------------------------------	----

Rated limits of this planer	12
-----------------------------	----

Checklist before starting	13
---------------------------	----

Planing step-by-step	13
----------------------	----

Maintenance & Adjustments	15
--------------------------------------	-----------

Periodic maintenance	15
----------------------	----

Inspecting/Replacing cutterhead knives	15
--	----

Replacing the v-belt	17
----------------------	----

Drive chain/gear lubrication	17
------------------------------	----

Recommended optional accessories	18
---	-----------

Parts list & diagrams	19-23
----------------------------------	--------------

RULES FOR SAFE OPERATION

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.

1. Do not operate this planer when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
2. The working area should be well lit, clean and free of debris.
3. Keep children and visitors at a safe distance when the planer is in operation; do not permit them to operate the planer.
4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
5. **Stay alert!** Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector. Wear face, eye, ear, respiratory and body protection devices.
7. Do not wear loose clothing, gloves, bracelets, necklaces or other jewelry while the planer is in operation. Wear protective hair covering to contain long hair and wear non-slip footwear.
8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the table surface before operating.
9. Keep hands well away from knives and all moving parts. Use a push stick to feed stock, and a brush, not hands, to clear away chips and dust.
10. Be sure that the knives are securely installed in the cutter head.
11. Always use clean, properly sharpened knives. Dirty or dull knives are unsafe and can lead to accidents.
12. Inspect stock and remove all foreign objects before planing. Make sure that any stock you plane is clean and free of any dirt, nails, staples, tiny rocks or any other foreign objects that may damage the planer knives. Only process natural solid wood boards. Never plane MDF, particle board, plywood, laminates or other synthetic materials.
13. Do not push or force stock into the cutter head. The planer will perform better and safer when working at the rate for which it was designed.
14. Kickback is when the workpiece is ejected at high speeds by the force of the cutter head. To minimize the risk of injury from kickback, use proper feeding technique and stand to one side, out of the path of a potential kickback.
15. Select appropriate feed speed for the stock being planed: high speed for softwood and slow for hardwoods.
16. Place stock firmly against the table and use suitable in-feed and out-feed support if stock is too long.
17. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning make sure it is properly attached before using the machine again.
18. Use of parts and accessories NOT recommended by GENERAL®INTERNATIONAL may result in equipment malfunction or risk of injury.
19. Never stand or lean on machinery. Serious injury could result if the tool is tipped over or if the cutting tool is unintentionally contacted.
20. Always disconnect the tool from the power source before servicing or changing accessories such as knives, or before performing any maintenance or cleaning, or if the machine will be left unattended.
21. Make sure that the switch is in the "OFF" position before plugging in the power cord.
22. Make sure the tool is properly grounded. If equipped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong.
23. Do not use this planer for other than its intended use. If used for other purposes, GENERAL® INTERNATIONAL disclaims any real implied warranty and holds itself harmless for any injury, which may result from that use.

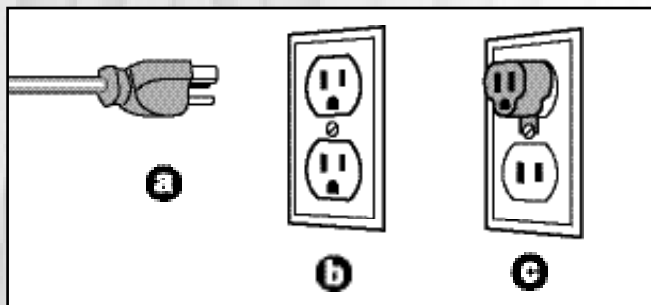


ELECTRICAL REQUIREMENTS



BEFORE CONNECTING THE MACHINE TO THE POWER SOURCE, VERIFY THAT THE VOLTAGE OF YOUR POWER SUPPLY CORRESPONDS WITH THE VOLTAGE SPECIFIED ON THE MOTOR I.D. NAMEPLATE. A POWER SOURCE WITH GREATER VOLTAGE THAN NEEDED CAN RESULT IN SERIOUS INJURY TO THE USER AS WELL AS DAMAGE TO THE MACHINE. IF IN DOUBT, CONTACT A QUALIFIED ELECTRICIAN BEFORE CONNECTING TO THE POWER SOURCE.

THIS TOOL IS FOR INDOOR USE ONLY. DO NOT EXPOSE TO RAIN OR USE IN WET OR DAMP LOCATIONS.



GROUNDING INSTRUCTIONS

In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock. The motor of this machine is wired for 120V single phase operation and is equipped with a 3-conductor cord and a 3-prong grounding plug **a** to fit a grounded type receptacle **b**. Do not remove the 3rd prong (grounding pin) to make it fit into an old 2-hole wall socket or extension cord. If an adaptor plug is used **c**, it must be attached to the metal screw of the receptacle.

Note: The use of an adaptor plug is illegal in some areas. Check your local codes. If you have any doubts or if the supplied plug does not correspond to your electrical outlet, consult a qualified electrician before proceeding.

CIRCUIT CAPACITY

Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician. If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

EXTENSION CORDS

If you find it necessary to use an extension cord with your machine, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool's plug. Repair or replace a damaged extension cord or plug immediately.

Make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

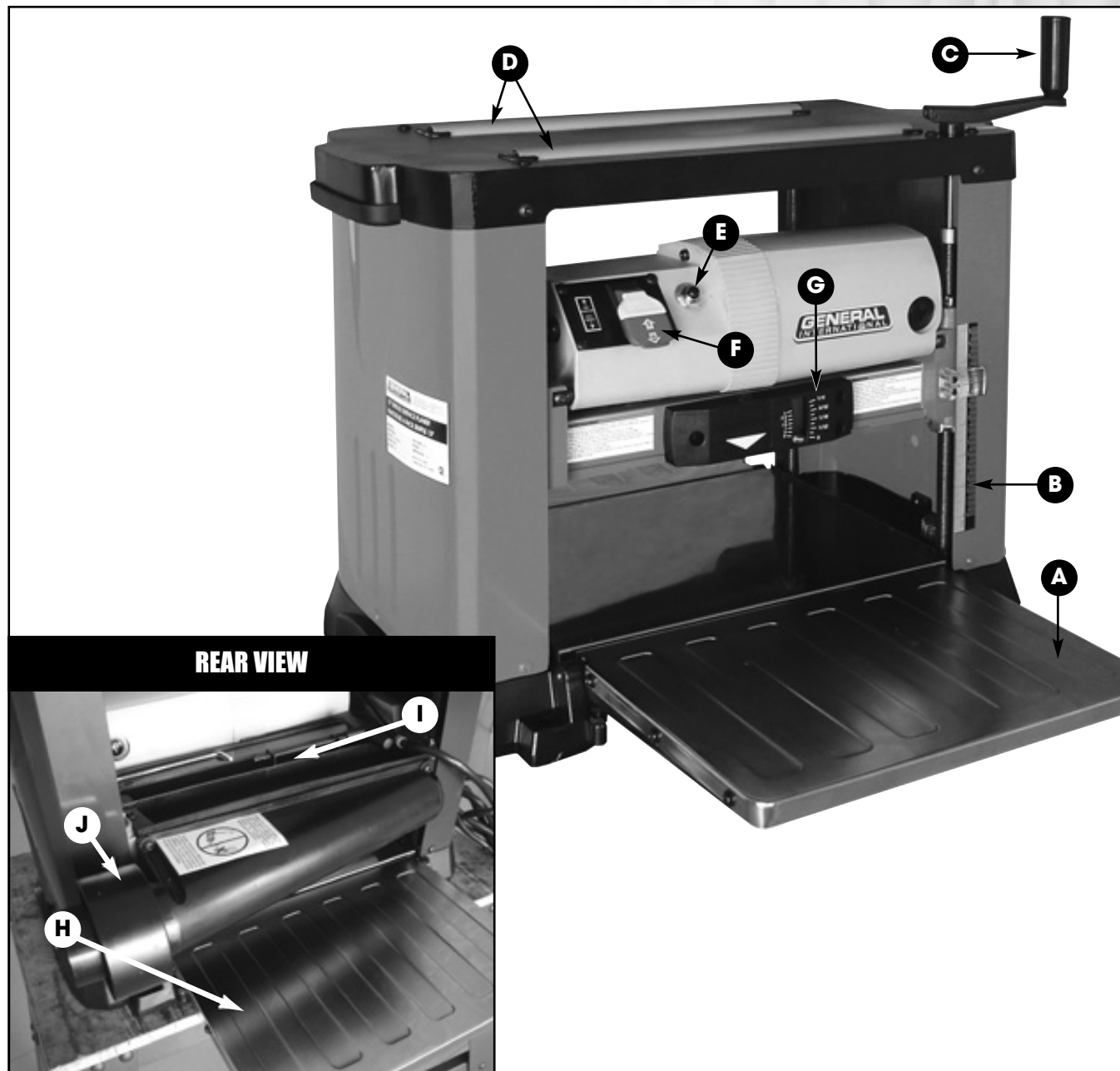
AMPERES (AMPS)	EXTENSION CORD LENGTH			
	25 FEET	50 FEET	100 FEET	150 FEET
< 5	18	16	16	14
6 TO 10	18	16	14	12
10 TO 12	16	16	14	14
12 TO 16	14	12	* NR	* NR

* NR = Not Recommended



13" PLANER WITH HELICAL CUTTER HEAD 30-005HC M1

IDENTIFICATION OF MAIN PARTS AND COMPONENTS



- a** IN-FEED TABLE
- b** STOCK THICKNESS SCALE
- c** HEIGHT ADJUSTMENT HANDLE
- d** RETURN ROLLERS
- e** CIRCUIT BREAKER
- f** ON/OFF SWITCH W/SAFETY KEY

- g** DEPTH OF CUT INDICATOR
- h** OUT-FEED TABLE
- i** TOOL STORAGE
- j** DUST CHUTE

UNPACKING

Carefully unpack and remove the planer and its components from the box and check for damaged or missing items as per the list of contents below.

NOTE: Please report any damaged or missing items to your General International distributor immediately.

LIST OF CONTENTS

QTY

A-	PLANER.....	1
B-	ADJUSTMENT HANDLE.....	1
C-	DUST CHUTE	1
D-	SAFETY KEY.....	1
E-	CAP SCREW	1
F-	BUTTON HEAD SCREW	4
G-	T-HANDLE WRENCH	1
H-	4 MM ALLEN KEY	1

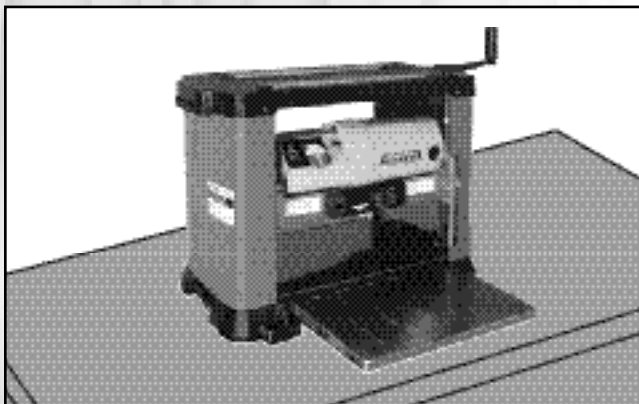


ASSEMBLY INSTRUCTIONS

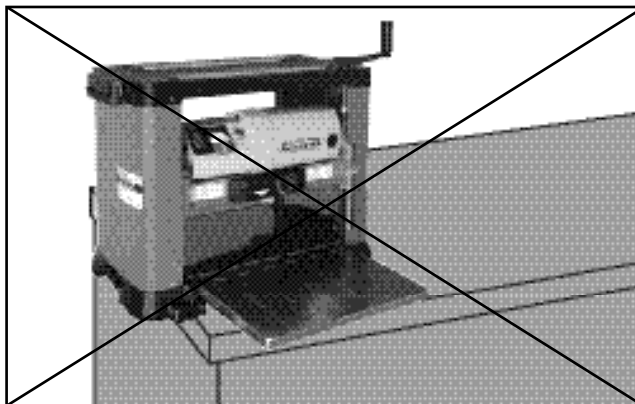
For your convenience this planer is shipped from the factory partially assembled and requires only minimal assembly and set up before being put into service.



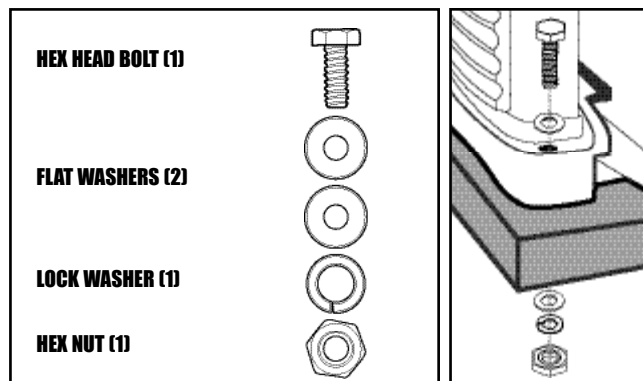
BEFORE STARTING THE INSTALLATION AND ASSEMBLY, MAKE SURE THAT THE POWER SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED. DO NOT PLUG IN OR TURN ON THE PLANER UNTIL YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS DESCRIBED IN THIS SECTION OF THE MANUAL.



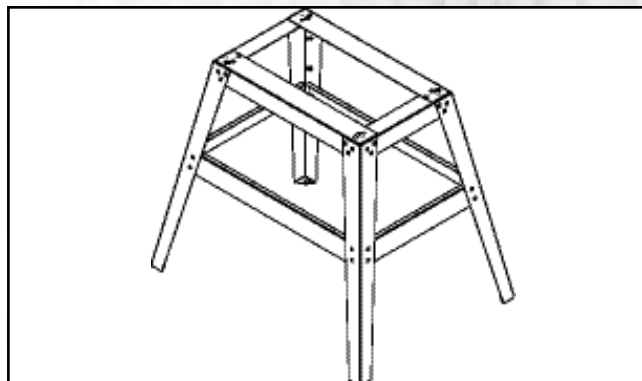
The unit should be installed on a flat, level, sturdy and stable surface, able to support the weight of the machine and the workpiece with ease.



Never install or operate the planer over the edge of a table, workbench or other mounting surface.



If a permanent shop placement or installation is practical, consider using the mounting holes and drilling matching through holes in your workbench or mounting surface to bolt the planer in place (hardware not included) on your workbench.



If you prefer an optional steel stand (item #30-006) is available from your local General International dealer.

ATTACH THE DEPTH OF CUT ADJUSTMENT HANDLE



Attach the adjustment handle on top of the machine as shown, using the supplied allen key and cap screw.

ATTACH THE DUST CHUTE



Install the dust chute on the rear of the machine as shown, using the 4 supplied button head screws.

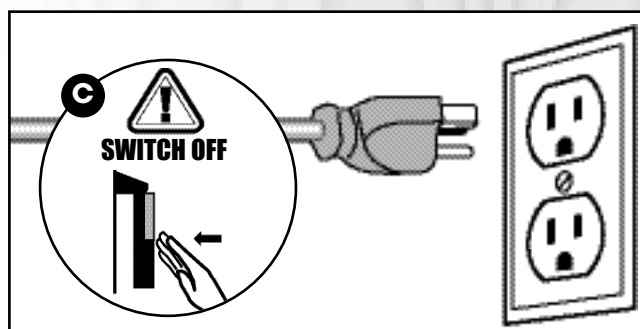
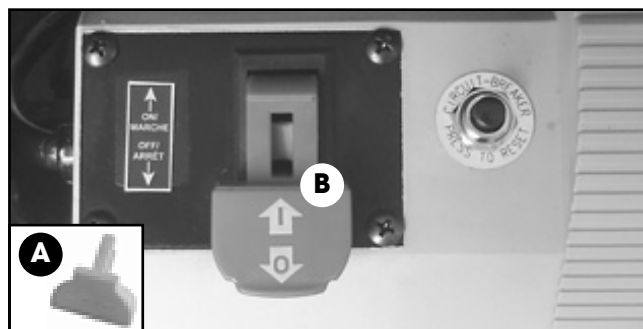
BASIC ADJUSTMENTS AND CONTROLS

CONNECTING TO A POWER SOURCE



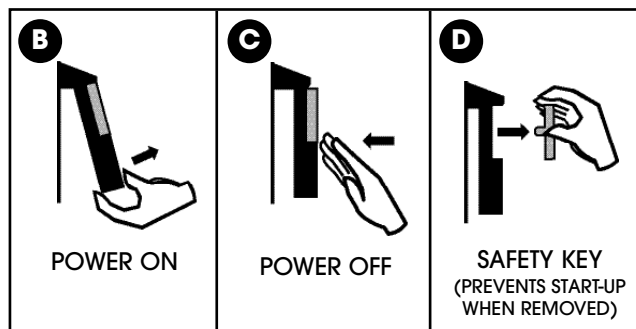
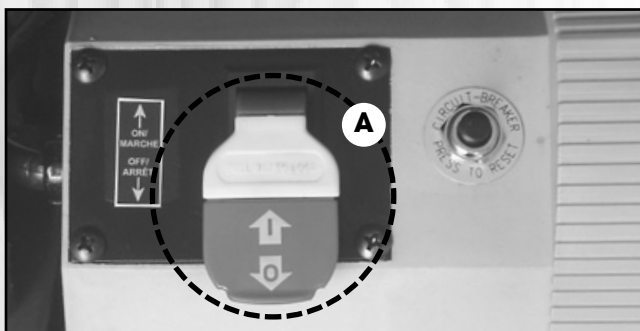
TO REDUCE THE RISK OF SHOCK OR FIRE DO NOT OPERATE THE UNIT WITH A DAMAGED POWER CORD OR PLUG. REPLACE DAMAGED CORD OR PLUG IMMEDIATELY.

TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THAT THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.



Once the assembly steps have been completed and the unit is safely secured or installed on a work surface such as a bench, stand or worktable, uncoil the power cord. With the switch locked-out (i.e. without the supplied safety key **A** installed, as shown in **B**, or in the off position **C**), plug the power cord into an appropriate outlet. Refer back to the section entitled Electrical Requirements and make sure all requirements and grounding instructions are followed. When planing operations have been completed unplug the unit from the power source.

ON/OFF POWER SWITCH



This planer is equipped with a rocker style ON/OFF switch located on the front left hand side of the cutter head. To start the planer, insert the lock-out key as shown in **A** and pull up on the lower portion of the switch as shown, **B**. To stop the planer, push down on the switch, **C**. To prevent unwanted or unauthorized start-up or usage, remove the lock-out key **D** and store it in a safe place, out of the reach of children, whenever the planer is not in use.



TO PREVENT UNWANTED OR UNAUTHORIZED START-UP OR USAGE, REMOVE THE LOCK-OUT KEY AND STORE IT IN A SAFE PLACE, OUT OF THE REACH OF CHILDREN, WHENEVER THE PLANER IS NOT IN USE.

SURGE PROTECTION/CIRCUIT BREAKER

The unit is equipped with a circuit breaker located to the right of the power switch, **A**, to protect the motor from power surges or spikes in line voltage. In the event of a power surge, the circuit breaker will be automatically tripped thereby cutting off the power to the motor.

To reset the circuit breaker after it has been tripped; set the power switch to the "off" position and depress the reset button on the circuit breaker, then restart the machine.



TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP BE CERTAIN THAT THE POWER SWITCH HAS BEEN SET TO THE OFF POSITION BEFORE RE-SETTING THE CIRCUIT BREAKER.

RAISING / LOWERING THE CUTTER HEAD

To adjust the depth of cut, the cutterhead assembly can be raised or lowered as needed by rotating the depth of cut adjustment handle.

NOTE: Each full clockwise rotation of the handle will lower the cutterhead by 1/16". Each full counterclockwise rotation will raise the cutterhead by 1/16".

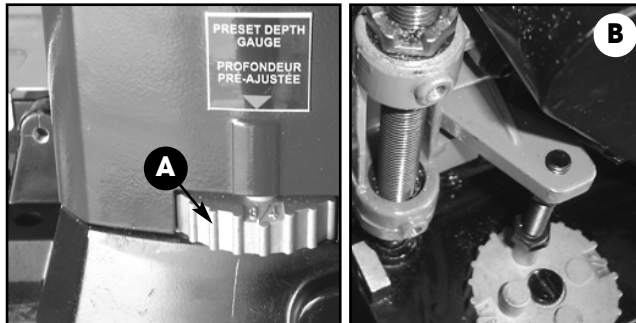


PRE-SET THICKNESS STOP GAUGE

The adjustable pre-set depth gauge located on the right side of the planer, **A**, allows the user to select one of four commonly used workpiece final thickness settings.

With the cutterhead set slightly above the height of the workpiece press down and rotate the spring loaded adjustment knob to select the desired final thickness setting from either 1/8", 1/4", 1/2" & 3/4". This will set the stop pin to prevent the cutterhead from going any lower than the selected thickness, **B**.

NOTE: Once you have planed the workpiece down to the selected thickness, do not attempt to lower the cutterhead further. Forcing the depth of cut handle when the cutterhead has bottomed out on the pre-set stop pin will damage the raising mechanism.



DEPTH OF CUT INDICATOR

The depth of cut indicator, **A**, will indicate how much material the cutterhead is set to remove from the workpiece for a given pass.

The pointer will read zero until the workpiece engages the front of the cutterhead. Place the workpiece under the front of the cutterhead and turn the height adjustment handle clockwise until the cutterhead makes contact with the workpiece & until the depth of cut indicator shows the reading that matches the desired cut.



Failure to follow these recommendations will lead to premature blade wear and may cause premature motor failure.

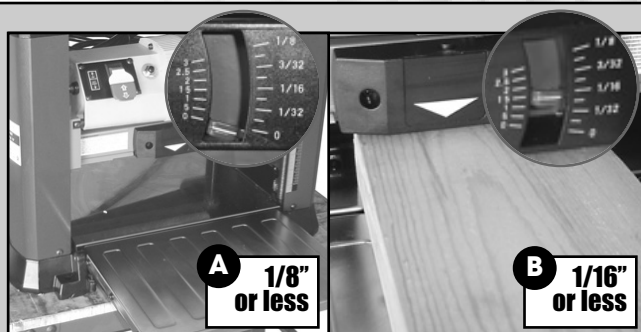
It is recommended that for both hard and soft wood:

For stock up to 6" in width, never remove more than 1/8" per pass, **A**.

For stock of 6"-13" in width, never remove more than 1/16" per pass, **B**.

Removing less material per pass and taking multiple passes is always preferred to more aggressive planing.

Advantages include longer blade life, better finish quality (resulting in less time sanding later) and less likelihood of removing too much material causing the workpiece to be too thin for its intended use.

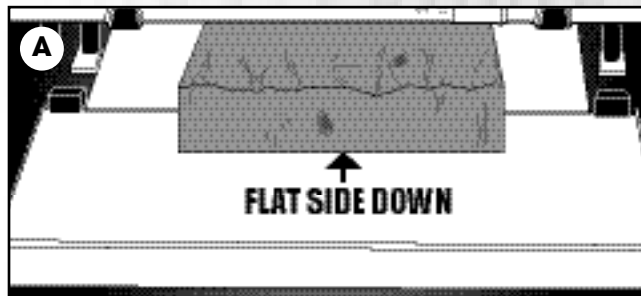


OPERATING INSTRUCTIONS

BASIC PRINCIPLES OF PLANING

This thickness planer is designed to remove material from the top face of a board in order to bring the board (or a series of boards) down to a specific desired thickness.

To obtain even, uniform thickness across the length of a board, the stock being planed must have one face that has already been machined perfectly flat (usually on a jointer) and the stock should be fed with this flat face against the table, **A**.



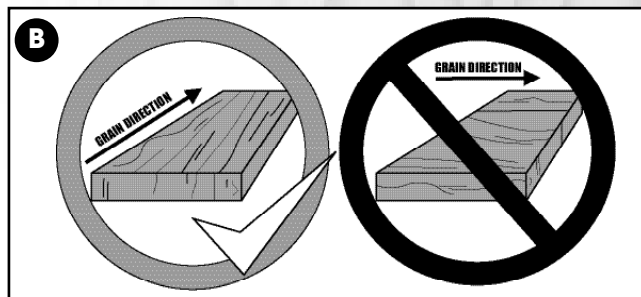
If it is not possible to machine one face perfectly flat before planing, take shallow passes all on the same face of the board until this face has been machined level. Then the board should be flipped over and the leveled face should be fed face down against the table to allow you to dimension the board to final thickness.

SELECTING BOARDS SUITABLE FOR PLANING

This planer is not intended (and should not be used) to plane any material other than solid wood.

The workpiece should always be fed through the planer in the general direction of the grain in the wood, **B**.

Before being fed through the planer all lumber should be inspected for debris and foreign objects such as staples or nails. Foreign objects stuck to, or embedded in your workpiece can be ejected from the machine at high speed and cause serious injury or damage cutter knives. Make sure to remove all such foreign objects from the wood before running it through the planer.



Select lumber carefully and avoid workpieces with loose or protruding knots. Workpieces that are twisted, severely deformed or warped should also be avoided. Warped, twisted, damaged or fragile stock runs an increased risk of jamming in or damaging the machine or cutters. There is also a much greater risk of injury to the operator or bystanders from kickback, where the workpiece is forcefully or violently ejected from the machine due to a jam, whenever working with such damaged or warped wood.

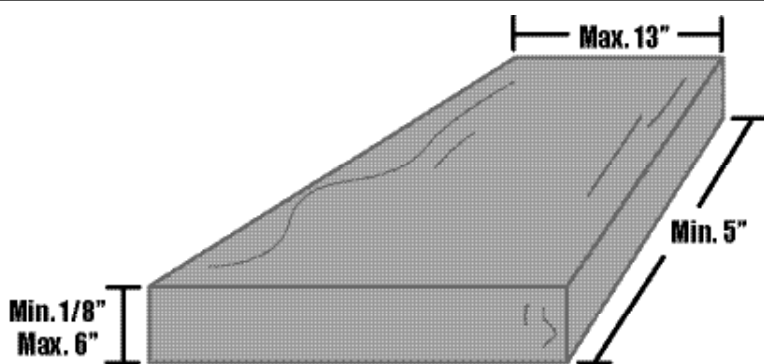
RATED LIMITS OF THIS PLANER

**THE MAXIMUM PLANING
WIDTH OF THIS UNIT IS 13".**

**THE MAXIMUM WORKPIECE
THICKNESS OF THIS UNIT IS 6"**

**THE MINIMUM THICKNESS TO WHICH A WORKPIECE
CAN BE SAFELY PLANED WITH THIS
UNIT IS 1/8" .**

**THE MINIMUM WORKPIECE LENGTH THAT CAN BE
SAFELY PLANED WITH THIS UNIT IS 5".**



RESPECT THE RATED LIMITS OF THIS MACHINE. IGNORING THESE LIMITS AND FEEDING NON COMPATIBLE STOCK INTO THIS PLANER CAN LEAD TO SERIOUS INJURY TO THE USER OR SHOP BYSTANDERS, AND CAUSE DAMAGE TO THE WORKPIECE AND/OR THE MACHINE. IF THE STOCK YOU WISH TO PLANE DOES NOT MEET OR COMPLY WITH THE LIMITATIONS LISTED ABOVE, FIND ANOTHER SAFER WAY TO PERFORM THE REQUIRED TASK.

CONNECTING TO A DUST COLLECTOR

A dust port **A** with a 4" opening is provided to accommodate connection to a dust collector (not included).

Be sure to use appropriate sized hose and fittings (not included) and check that all connections are sealed tightly to help minimize airborne dust.

If you do not already own a dust collection system consider contacting your General® International distributor for information on our complete line of dust collection systems and accessories or visit our Web Site at www.general.ca

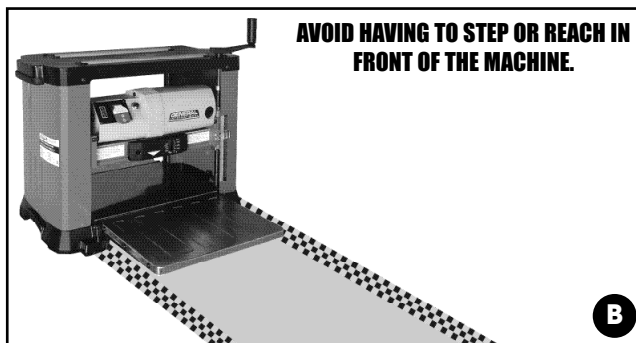


CHECKLIST BEFORE STARTING

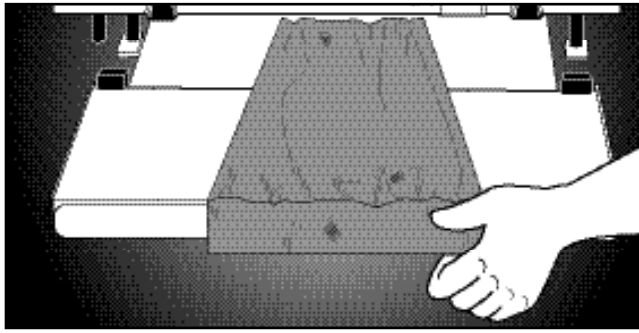


VERIFY ALL CHECK POINTS BEFORE STARTING. FAILURE TO COMPLY CAN RESULT IN SERIOUS INJURIES.

- Make sure the board has been inspected and is suitable for planing as explained in section "Selecting boards suitable for planing".
- Make sure you and any assistants are wearing safe appropriate workshop attire. Roll up long sleeves, secure long hair and remove any jewelry: watches, rings, bracelets or anything that could become caught in the moving parts, potentially causing serious injury.
- Make sure to have on safety glasses as well as hearing and respiratory protection at all times when using the planer.
- To reduce the risk of damage to the planer or the workpiece, as well as a potential for personal injury, after initial set-up as well as before each use, make sure that everything is securely installed and that all fasteners and moving parts on this machine are locked in place before starting the machine.
- If multiple boards are to be planed, collect all work-pieces together and set them nearby on a table or bench within easy reach **A**. To limit the potential for injury in the event of a kickback, avoid having to step or reach in front of the machine to pick up the next workpiece **B**.



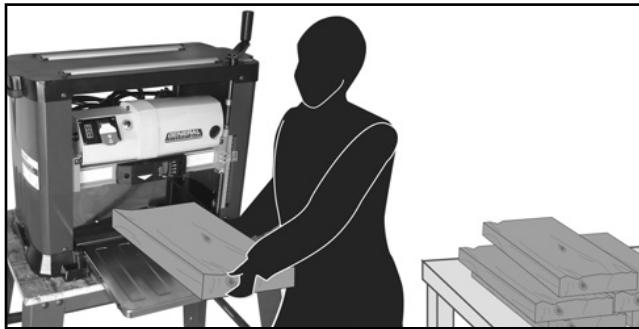
PLANING STEP-BY-STEP



1. With the planer turned off, position the workpiece on the infeed table with the flat face down and the face to be planed facing up.



3. Slide the workpiece up to the cutterhead and using the depth of cut adjustment handle, raise or lower the cutterhead as needed to obtain the desired depth of cut.



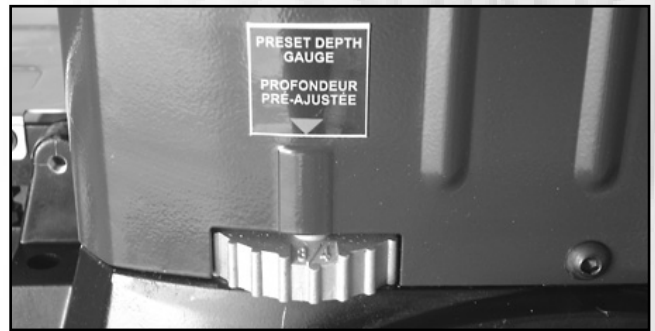
5. Stand to one side of the machine and set the board back on the infeed table with the face to be planed facing up.



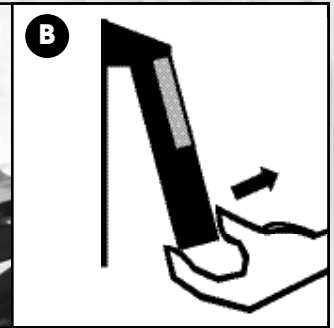
TO LIMIT THE POTENTIAL FOR INJURY IN THE EVENT OF A KICKBACK, AVOID STANDING DIRECTLY IN LINE WITH THE FRONT OR BACK OF THE PLANER WHENEVER A BOARD IS ENGAGED IN THE CUTTERHEAD.



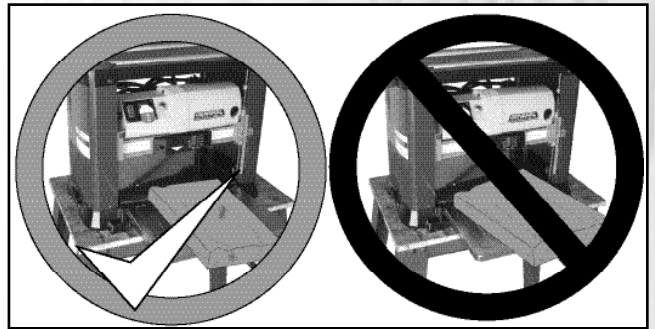
7. Slowly slide the workpiece forward until the infeed roller "grips" the board.



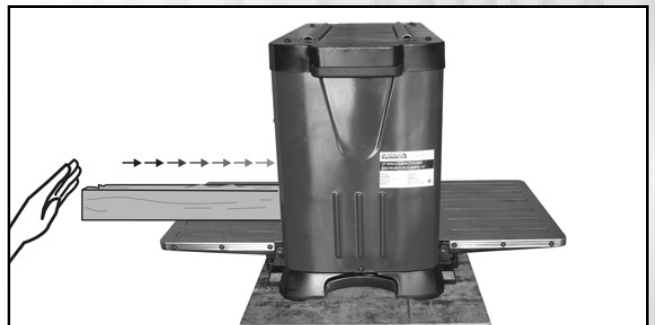
2. If a specific pre-set thickness is required, set the depth stop to the desired final workpiece thickness.



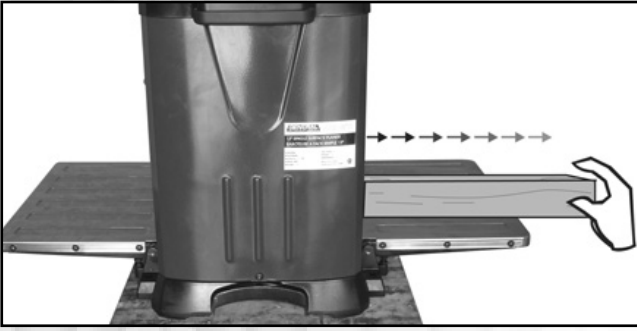
4. Set the board aside, then insert the safety key in the switch **A** and turn on the planer **B**.



6. Align the board laterally so that it will be fed through the planer in the general direction of the grain, and allow the workpiece enough clearance to feed properly without rubbing or catching on either side of the machine.



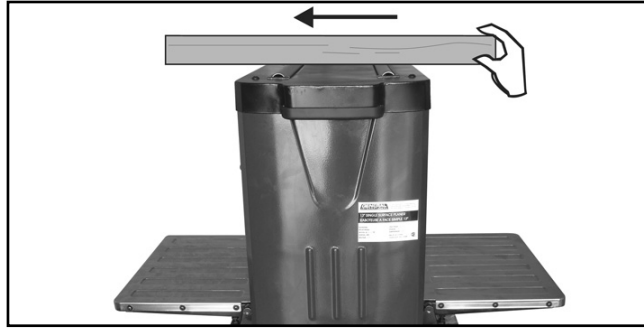
8. Release the board allowing the feed roller to automatically feed the board through the planer.



9. Step to the rear of the machine and recover the planed board on the outfeed table once it has cleared the outfeed roller and has stopped advancing.



NEVER PUSH, PULL OR OTHERWISE TRY TO MOVE OR RE-POSITION THE WORKPIECE ONCE IT IS IN THE CONTROL OF THE AUTOMATIC FEED ROLLERS.



10. The return rollers on the top of the planer can be used to pass the workpiece back to the front of the machine for repeat passes.
11. Repeat these steps as needed for all boards that need to be planed to the same thickness.

MAINTENANCE AND ADJUSTMENTS

PERIODIC MAINTENANCE



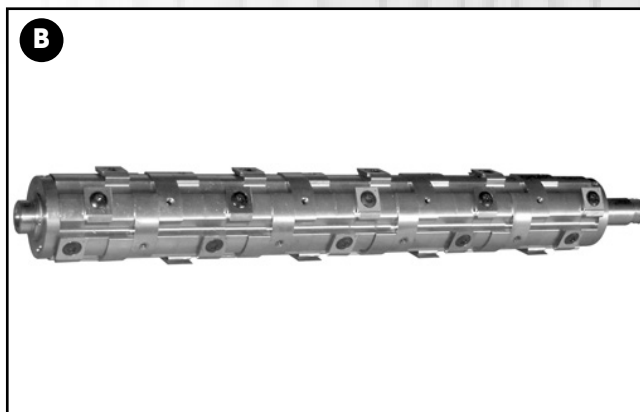
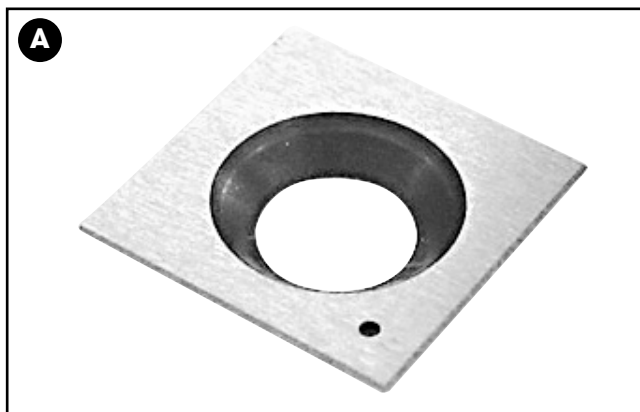
MAKE SURE THE PLANER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENT.

- Inspect/test the ON/OFF switch before each use. Do not operate the planer with a damaged switch; replace a damaged switch immediately.
- Keep the machine as well as the in-feed out-feed tables clean and free of saw dust, woodchips, pitch or glue. Vacuum or brush off any loose debris and wipe down the machine and the tables occasionally with a damp rag.
- An occasional light coating of paste wax can help protect the tables' surface and reduce workpiece friction. Ask your local distributor for suggestions on aftermarket surface cleaners, protectant and dry lubricants based on what is readily available in your area.
- Avoid using silicon based products that may affect wood finishing products such as oil, solvent or water-based stains, varnishes and lacquers.
- Periodically inspect the power cord and plug for damage. To minimize the risk of electric shock or fire, never operate the planer with a damaged power cord or plug. Replace a damaged power cord or plug at the first visible signs of damage.
- The motor and cutterhead bearings are sealed and permanently lubricated – no further lubrication is required.
- The drive gears, chain and elevation screws should be cleaned of woodchips, dust, debris and old grease after every 10-15 hours of use. After cleaning, re-apply a generous coating of any common automotive bearing grease.
- Regularly inspect planed workpieces for signs of knife damage or wear and replace damaged or worn knives immediately.

INSPECTING/REPLACING CUTTERHEAD KNIVES



MAKE SURE THE PLANER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE.

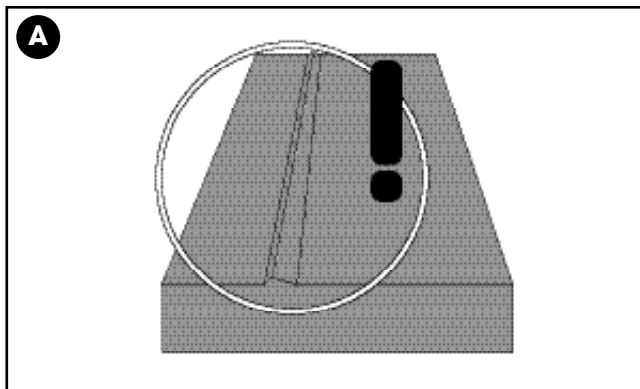


There are 26 reversible two-sided high speed steel inserts (knives) **A** installed in the helical cutter head **B** at the factory. With usage and normal wear over time, it will eventually become necessary to reverse and/or replace the inserts. To maintain even insert wear always reverse all 26 inserts each time knife replacement is required. If one of the inserts has been nicked or damaged on one of its edges, it can be simply reversed instead of replaced.

When needed, replacement inserts **B** can be ordered through your local General International distributor under item #30-007.

Observing planed workpieces as they come out of the machine and looking for signs of knife damage or wear is the best method to help you to determine when knives are due to be changed.

Signs to look for include:



1. A raised ridgeline in the workpiece that runs a straight line from beginning to end of the board, **A**. This is generally an indication that one of the knives has been nicked or damaged by a foreign object such as a nail, staple or other hard object hidden or embedded in the workpiece.
2. A slight washboard or chatter effect, **B**, which can be an indication of uneven knife wear causing one knife to cut slightly deeper than the other.
3. Rough, irregular, torn or fuzzy grain on a freshly planed surface may be a sign of worn or dull blades causing the wood to tear out. Sharp blades cut crisply and leave a relatively smooth finish.

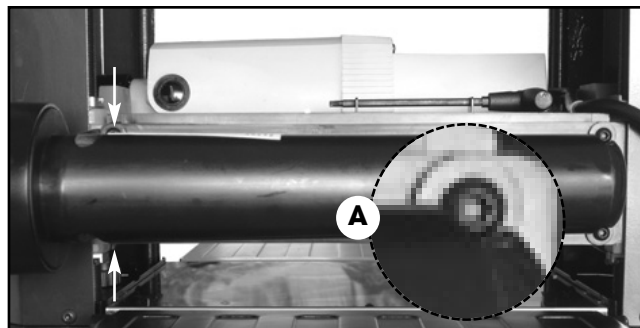
Note: Fuzzy grain can also be a sign of high moisture content in the workpiece. If knives have recently been changed or if you suspect that moisture content and not dull knives is the cause, set the workpiece aside and test by planing other boards with known or acceptable moisture content. If the planed results using a different workpiece are smooth, then moisture content in your wood is the problem - no adjustments can be made to the machine for this. Set the "wet" stock aside and simply work with drier wood.



1. Turn off and unplug the machine from the power source.
2. Set the pre-set depth gauge to 3/4" so that the stop pin prevents the cutter head from going any lower.



4. Using the supplied allen key, loosen and remove the 2 button head screw **B**, then remove the chip deflector.



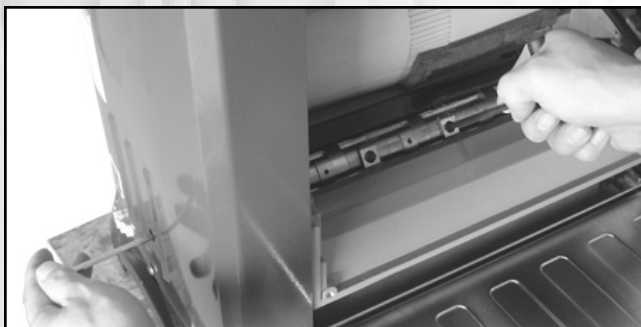
3. Using the supplied allen key, loosen and remove the 4 button head screws **A**, and remove the dust chute.



5. Insert the supplied allen key into the hole on the side of the planer as shown to keep the cutter head from turning while changing knives.



NEVER RUN A FINGER OR OTHER BODY PART ALONG THE CUTTING EDGE OF THE KNIFE TO TEST FOR SHARPNESS OR TO DETERMINE IF THE EDGE IS WORN OR HAS ALREADY BEEN USED. FAILURE TO HEED THIS WARNING CAN LEAD TO SERIOUS INJURY.

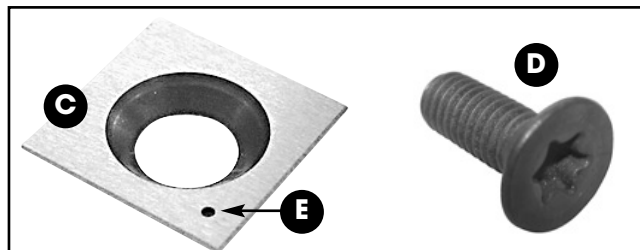


6. Using the supplied t-handle wrench, loosen the screws as shown, then remove the screws and inserts.
7. Thoroughly clean the housing and cavity before reversing/replacing an insert.
9. Place the insert in the housing so it sits flush against the supporting edge **F** and firmly secure it in place with a screw.

Note: To avoid stripped screws and cracked inserts, do not overtighten the screws

Note: When tightening the screws, make sure the head of the screw is aligned flush with the hole of the insert and does not protrude.

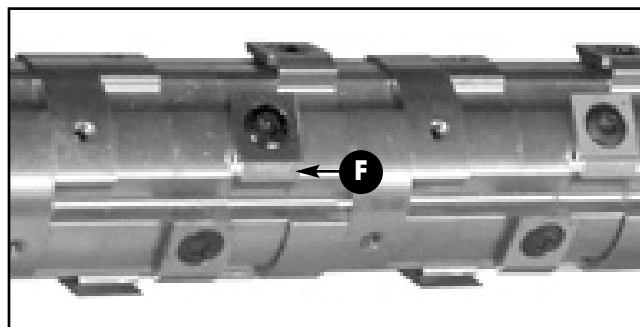
10. Re-install the chip deflector.
11. Re-install the dust chute.



Important! To prevent knife height discrepancies, the inserts and screws must be clean and free of debris.

8. Thoroughly clean the inserts **C** and screws **D** using a lacquer thinner and small brush then apply a light coating of machine oil on the screws, taking care to remove any excess.

Tip: When reversing the inserts in the cutter head, refer to the etched mark **E on the inserts to keep track of the rotations.**



REPLACING THE V-BELT

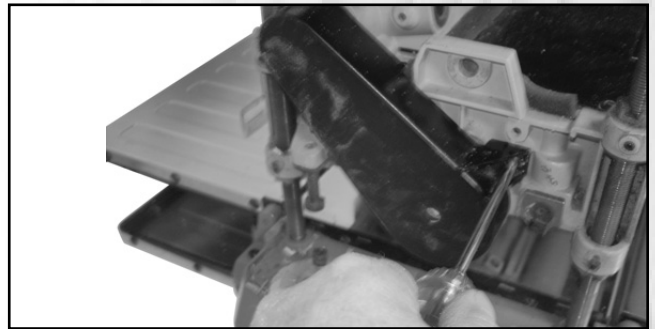
The cutter head is driven by a flat ribbed belt that is located on the right-hand side of the planer facing the infeed side.



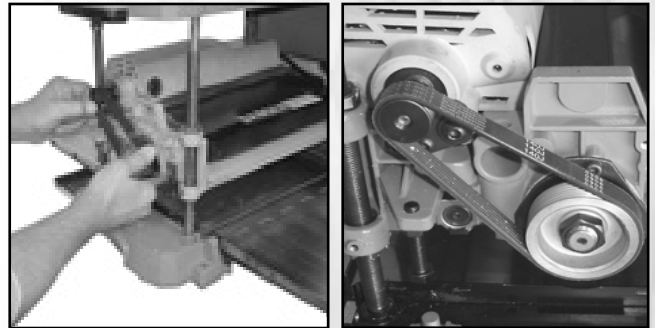
MAKE SURE THE PLANER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE.



1. Using a 4 mm Allen wrench, remove the 5 button head cap screws holding the right hand side cover on. Lift the cover upwards slightly while pulling the bottom outwards until it is off of the machine.
3. Roll the belt off of the pulleys by spinning the larger pulley and pulling the belt off of the smaller pulley one rib at a time until it is free from the pulleys.
4. Install the replacement belt in the reverse order of removal.
5. Re-install the belt guard.
6. Re-install the right hand side cover.



2. Using a phillips screwdriver, remove the 2 phillips head screws holding the belt guard in place.

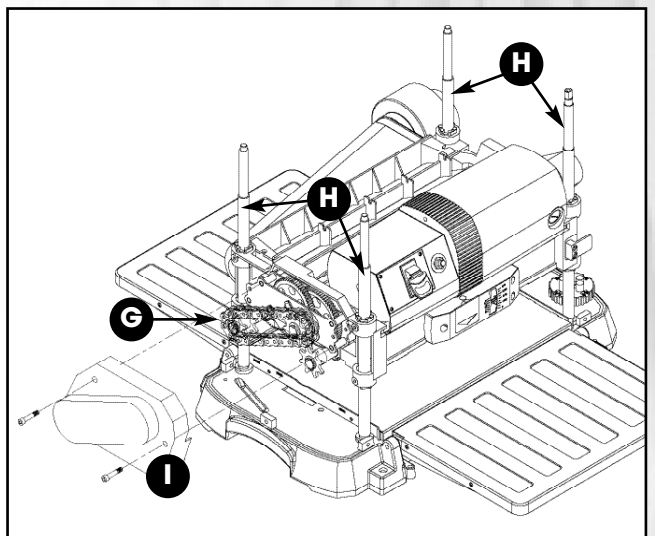


DRIVE CHAIN/GEAR LUBRICATION

Periodically the drive chain & gears **G** and elevation screws **H** will need to be cleaned and greased to help maintain smooth feeding and contribute to longer machine life and trouble free operation.

To clean and grease the drive chain & gears and elevation screws:

1. Turn off and unplug the machine from the power source.
2. Unfasten the 5 screws holding the frame cover in place and remove frame cover.
3. Unfasten the 2 screws holding the drive chain/gear cover in place and remove the drive chain/gear cover, **I**.
4. Remove old grease and dust deposits by wiping with a dry rag.
5. Apply generous dabs of any common automotive bearing grease to the gears & chain, **G** and four elevation screws **H**.
6. Re-install the chain/gear cover and frame cover.



RECOMMENDED OPTIONAL ACCESSORIES

We offer a large variety of products for increased convenience, productivity, accuracy and safety when using your planer. Here's a small sampling of optional accessories available from your local General International dealer.

For more information about our products, please visit our website at www.general.ca



DUST COLLECTORS

We offer a wide selection of top quality dust collectors to suit all your shop needs. Dust collectors contribute to a cleaner more healthful workshop environment.



ROLLER STANDS **#50-150, #50-170 & #50-167S**

We offer a selection of roller stands for added in-feed or out-feed support when working with longer stock.



HEAVY DUTY OPEN BASED STEEL STAND **#30-006**

Easy to assemble, wide based stable design with mounting slots for permanent planer installation. Foot print measures 33" (833) x 24 1/2". Floor to top of stand height: 28" (711mm).

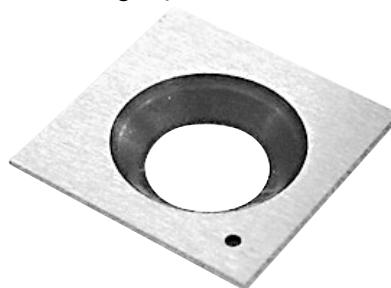
ELECTRONIC EARMUFFS - #99-200

Highly efficient noise reduction to help protect your hearing when operating power tools.

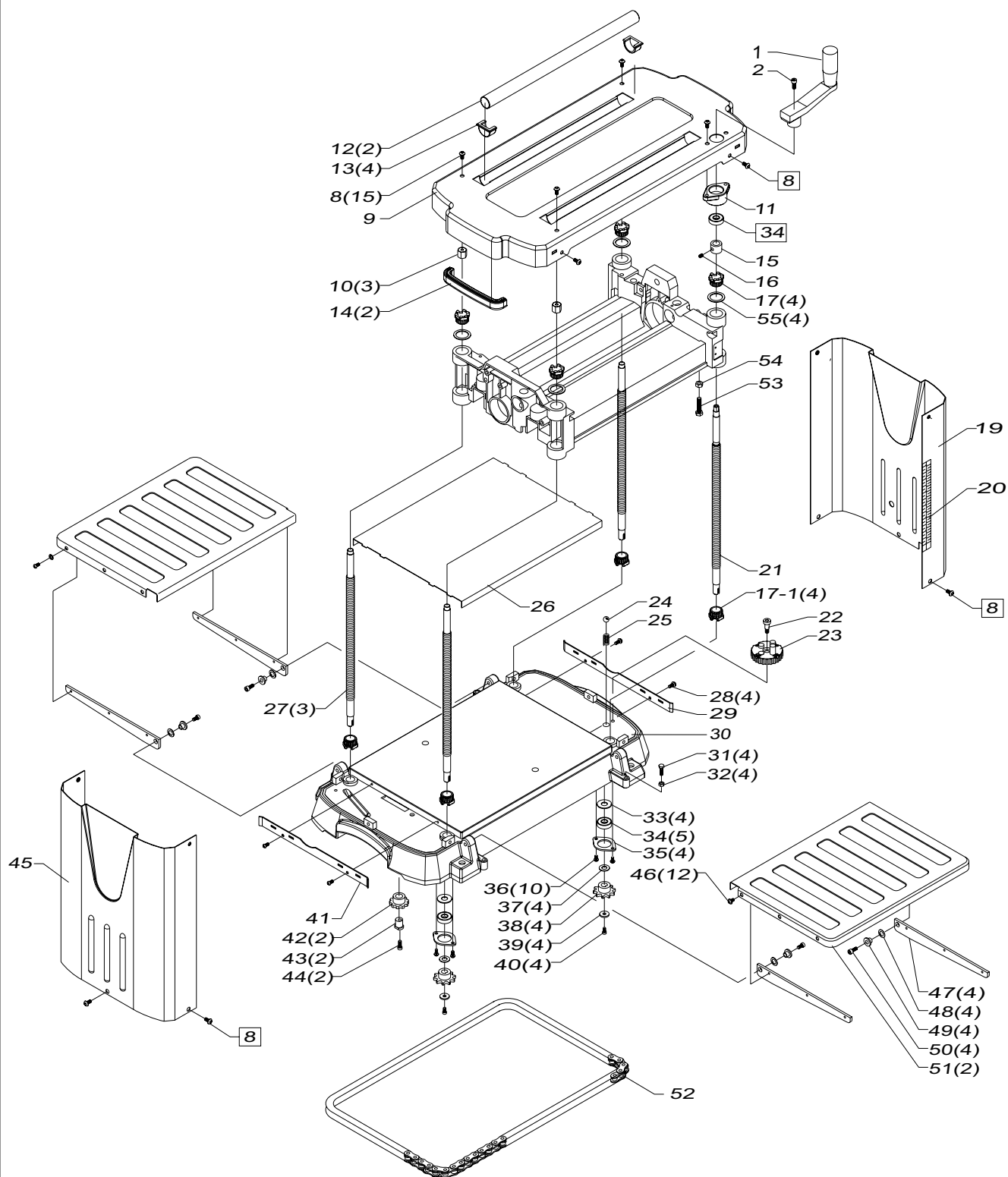


REPLACEMENT INSERTS #30-007

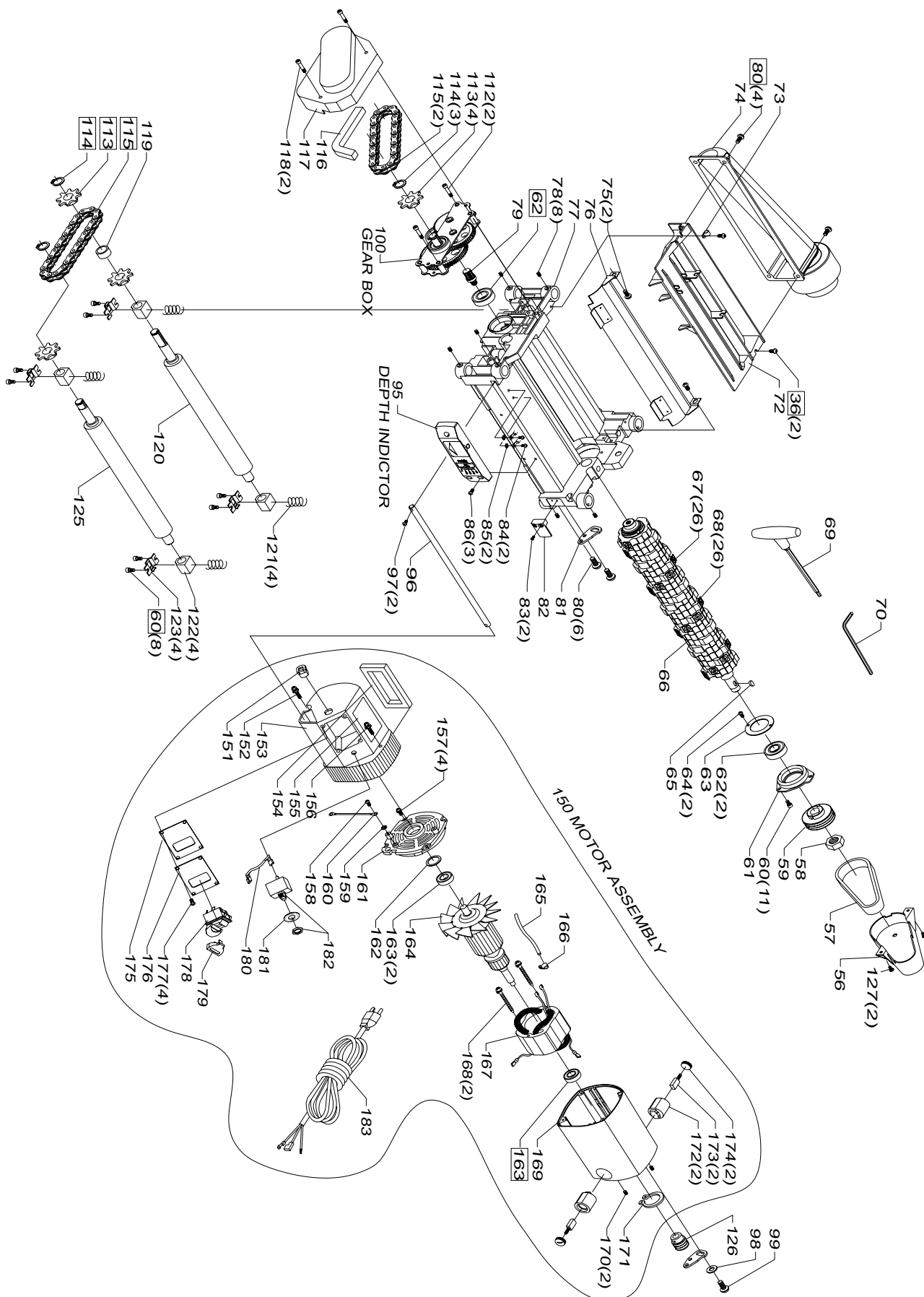
Reversible two-sided high speed steel inserts



FRAME ASSEMBLY



MAIN ASSEMBLY



**PARTS LIST
30-005HC M1**

PART NO.	REF. NO.	DESCRIPTION	SPECIFICATION	QTY
1	30005-01	HANDLE ASSEMBLY		1
2	30005-02	CAP SCREW	M5xP0.8x20L	1
8	30005-08	BUTTON HEAD SCREW	M6xP1.0x8L	15
9	30005-09	TOP COVER		1
10	30005-10	SHAFT BUSHING		3
11	30005-11	UPPER BEARING SEAT		1
12	30005-12	RETURN ROLLER		2
13	30005-13	ROLLER SEAT		4
14	30005-14	LIFTING HANDLE		2
15	30005-15	SPACER		1
16	30005-16	SET SCREW	M5xP0.8x5L	1
17	30005-17	UPPER ELEVATION NUT		4
17-1	30005-17-1	FLANGE NUT	M6xP1.0	4
19	30005-19	SIDE PANEL (RIGHT)		1
20	30005-20	THICKNESS SCALE		1
21	30005-21	HEIGHT ADJUSTMENT LEAD SCREW		1
22	30005-22	CAP SCREW	M6xP1.0	1
23	30005-23	PRE-SET STOP DIAL		1
24	30005-24	STEEL BALL	Ø10	1
25	30005-25	SPRING	Ø7.62xØ15.75x0.7t	1
26	30005-26	MAIN TABLE		1
27	30005-27	LEAD SCREW		3
28	30005-28	PHILLIPS HEAD SCREW	M4xP0.7x10L	4
29	30005-29	RIGHT GUIDE PLATE		1
30	30005-30	BASE		1
31	30005-31	HEX. HEAD BOLT	M6xP1.0x20L	4
32	30005-32	HEX. NUT	M6xP1.0	4
33	30005-33	FLAT WASHER	Ø12.2xØ25.8x2t	4
34	30005-34	SPINDLE BEARING	6000ZZ	5
35	30005-35	BEARING SEAT		4
36	30005-36	BUTTON HEAD SCREW	M5xP0.8x12L	10
37	30005-37	FLAT WASHER	Ø10.3xØ18x1t	4
38	30005-38	SPINDLE SPROCKET		4
39	30005-39	FLAT WASHER	Ø4.2xØ15x2t	4
40	30005-40	CAP SCREW	M4xP0.7x12L	4
41	30005-41	LEFT GUIDE PLATE		1
42	30005-42	IDLE WHEEL		2
43	30005-43	ECCENTRIC BUSHING		2
44	30005-44	CAP SCREW	M5xP0.8x25L	2
45	30005-45	SIDE PANEL - LEFT		1
46	30005-46	PHILLIPS HEAD SCREW	M4xP0.7x6L	12
47	30005-47	TABLE SUPPORT BRACKET		4
48	30005-48	LOCK WASHER	TP305	4
49	30005-49	TABLE BUSHING		4
50	30005-50	PHILLIPS HEAD SCREW	M6xP1.0x16L	4
51	30005-51	TABLE EXTENSION		2
52	30005-52	ELEVATION CHAIN	#410, 100	1
53	30005-53	HEX HEAD BOLT	M8xP1.25x45L	1
54	30005-54	HEX NUT	M8xP1.25	1
55	30005-55	FLAT WASHER		4
56	30005-56	BELT GUARD		1
57	30005-57	BELT	140 J6	1
58	30005-58	L.H. HEX NUT	M16xP2.0L.H.	1
59	30005-59	CUTTER HEAD DRIVE PULLEY		1
60	30005-60	BUTTON HEAD SCREW	M5xP0.8x12L	11

PARTS LIST
30-005HC M1

PART NO.	REF. NO.	DESCRIPTION	SPECIFICATION	QTY
61	30005-61	CUTTER HEAD BEARING SEAT		1
62	30005-62	CUTTER HEAD BEARING	6203ZZ	2
63	30005-63	BEARING RETAINER		1
64	30005-64	PHILLIPS HEAD SCREW	M3xP0.5X8L	2
65	30005-65	KEY	5x5x12mm	1
66	30005-66	HELICAL CUTTER HEAD		1
67	30005-67	CUTTER HEAD INSERTS (see #30-007 - set of 10 inserts)	14x14x2mm†	26
68	30005-68	TORX SCREW (see #30-008)	M5xP0.8	26
69	30005-69	TORX WRENCH		1
70	30005-70	ALLEN WRENCH	4x120mmL	1
72	30005-72	CHIP BREAKER		1
73	30005-73	POWER CORD CLAMP	GCL 5/16 S	1
74	30005-74	DUST CHUTE		1
75	30005-75	BUTTON HEAD SCREW	M6xP1.0x10L	2
76	30005-76	CHIP DEFLECTOR		1
77	30005-77	UPPER FRAME		1
78	30005-78	SET SCREW	M5xP0.8x6L	8
79	30005-79	CUTTER HEAD PINION		1
80	30005-80	BUTTON HEAD SCREW	M6xP1.0x12L	6
81	30005-81	MOTOR MOUNTING PLATE		1
82	30005-82	POINTER		1
83	30005-83	PHILLIPS HEAD SCREW	M3xP0.5x16L	2
84	30005-84	PHILLIPS HEAD SCREW	M5xP0.8x8L	2
85	30005-85	EXT TOOTH WASHER	Ø5	2
86	30005-86	PHILLIPS HEAD SCREW	M4xP0.7x12L	3
95	30005-95	DEPTH OF CUT INDICATOR		1
96	30005-96	MOTOR PIVOT ROD		1
97	30005-97	BUTTON HEAD SCREW	M5xP0.8x16L	2
98	30005-98	FLAT WASHER	Ø8.4xØ18x2†	1
99	30005-99	BUTTON HEAD SCREW	M8xP1.25x20L	1
100	30005-100	GEAR BOX ASSY		1
112	30005-112	CAP SCREW	M5xP0.8x35L	2
113	30005-113	SPROCKET	8T	4
114	30005-114	CIRCLIP	STW15	3
115	30005-115	GEARBOX DRIVE CHAIN	#410, 27	2
116	30005-116	SPONGE		1
117	30005-117	GEARBOX GUARD		1
118	30005-118	CAP SCREW	M5xP0.8x40L	2
119	30005-119	SPROCKET SPACER		1
120	30005-120	OUTFEED ROLLER		1
121	30005-121	SPRING		4
122	30005-122	BEARING BLOCK		4
123	30005-123	BEARING BLOCK RETAINER		4
125	30005-125	INFEED ROLLER		1
127	30005-127	PHILLIPS HEAD SCREW W/WASHER	M4xP0.7x8L	2
150	30005-150	MOTOR ASSY		1
151	30005-151	STRAIN RELIEF BUSHING	HALO(6P3-4)	1
152	30005-152	PHILLIPS HEAD SCREW	M5xP0.8x40L	1
153	30005-153	FAN HOUSING		1
154	30005-154	SPONGE GASKET		1
155	30005-155	WARNING LABEL (UL)		1
156	30005-156	PHILLIPS HEAD SCREW	M5xP0.8x50L	1
157	30005-157	PHILLIPS HEAD SCREW	M4.8xP1.2x16L	4
158	30005-158	PHILLIPS HEAD SCREW	M5xP0.8x8L	1
159	30005-159	SPROCKET WASHER	M5	1
160	30005-160	GROUND WIRE	300mm +/- 3mm±	1

**PARTS LIST
30-005HC M1**

PART NO.	REF. NO.	DESCRIPTION	SPECIFICATION	QTY
161	30005-161	MOTOR FAN COVER		1
162	30005-162	WAVE WASHER		1
163	30005-163	BEARING	6201 LLB	2
164	30005-164	ARMATURE		1
165	30005-165	SLEEVE		1
166	30005-166	POWER CORD CLAMP	GCL5/16S	1
167	30005-167	STATOR	120V/60Hz	1
168	30005-168	PHILLIPS HEAD SCREW	M4.8x75L	2
169	30005-169	MOTOR HOUSING		1
170	30005-170	SET SCREW	M5xP0.8x8mmL	2
171	30005-171	RETENTION RING	RTW32	1
172	30005-172	BRUSH HOLDER	TP305	2
173	30005-173	MOTOR BRUSH		2
174	30005-174	BRUSH CAP	TP305	2
175	30005-175	INSULATOR		1
176	30005-176	SWITCH COVER		1
177	30005-177	PHILLIPS HEAD SCREW	3/16"x3/8"L	4
178	30005-178	SWITCH	HT-18 "i	1
179	30005-179	SWITCH KEY		1
180	30005-180	CIRCUIT BREAKER CONNECTING WIRE		1
181	30005-181	NAME PLATE		1
182	30005-182	CIRCUIT BREAKER RESET	20A,A-0701	1
183	30005-183	POWER CORD (UL/CSA)	14AWG,120V,2.4mL	1

NOTES

MODEL 30-005HC M1



8360 Champ-d'Eau, Montreal (Quebec) Canada H1P 1Y3

Tel.: (514) 326-1161

Fax: (514) 326-5565 - Parts & Service / Fax: (514) 326-5555 - Order Desk

orderdesk@general.ca
www.general.ca

IMPORTANT

When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.